

Work Order ID 51728

August 31, 2009 11:22:07 AM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *09-08-31*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

Sorberko

HG for BG 09/09/10

51728

Work Order ID 51728

August 31, 2009 11:22:07 AM



Page 2

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Item Name: Skidtube LH

Stop



Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

③ Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod

m111682

10-Grind welds flush as per Dwg D2750

9-8-31

9-9-1

3 BB 09-09-01

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-011 PAR #: _____ Fault Category: Skid to be NCR: Yes No DQA: / Date: 05.05.16
 Resolution: re work Disposition: re work QA: N/C Closed: / Date: 09.05.16

NCR: <u>51728</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>9/06/1</u>	<u># 110.3</u>	After cut RWD End of tube it was found that the two RWD "insert holes" Detail A" were drilled off center.	<u>/</u> <u>09/06/1</u>	Fill both holes on one side with weld. A/R# <u>M111682</u> - Build weld smooth inside and outside - Re Drill Per Dwg.	<u>09/09/01</u> <u>09/09/01</u> <u>09/09/01</u>	<u>S</u> <u>09/09/02</u>	<u>/</u> <u>09/06/31</u>	<u>S</u> <u>09/06/31</u>
		R.C. Bending Process on lower than in jig wasn't positions correctly. - Process -	<u>/</u> <u>09/06/31</u>				<u>/</u> <u>09/06/31</u>	<u>S</u> <u>09/06/31</u>

NOTE: Date & initial all entries

Work Order ID 51728

August 31, 2009 11:22:07 AM



Page 3

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

12- Scribe batch# inside per dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

=> 802/01/02

Memo

0.00

(X) /

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> 809/02/02

Memo

0.00

(X) /

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

(X) 2 MB 0909-03

Work Order ID 51728

August 31, 2009 11:22:07 AM



Page 4

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Item Name: Skidtube LH

Stop



Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 09-08-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

9-9-3

0.00

Quality Control

Work Order ID 51728

August 31, 2009 11:22:07 AM



Page 5

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Item Name: Skidtube LH

Stop



Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ ☐ Sikaflex-291

batch: ☐ ☐ ☐

exp. date: _____

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐ ☐ ☐ Aluminum Rod

batch:

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

M112391 - ANM9-9-3
9-9-3

BE 9-9-4

9-9-4

Work Order ID 51728

August 31, 2009 11:22:07 AM



Page 6

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

=> S 08/09/08

Memo

0.00



180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> S 08/09/08

Memo

0.00



190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

B/K 09-09-8

0.00



Work Order ID 51728

August 31, 2009 11:22:07 AM



Page 7

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

M112260
START TIME: 10:45AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:15AM

0.00

JH 09/09/08

1 0

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

Inspect for foreign object per QSI 024

0.00

JH 09-09-09 0

220



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

1- Install inserts as per Dwg D2750

0.00

MD 09/09/10

(XL)

Work Order ID 51728

August 31, 2009 11:22:07 AM



Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
	HandFinish	0.00				(X1)			
Hand Finishing	Memo								
	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>ALC 8</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M102391</u> EXP DATE: <u>10/20</u>								MD 09/09/10
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M101223</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>M104251</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							(X) 4
Quality Control	Memo								

Work Order ID 51728

August 31, 2009 11:22:07 AM



Page 9

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/9/10

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

S

8/8/10



270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

Rev G

9/9/10

Work Order ID 51728

August 31, 2009 11:22:07 AM



Page 10

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/10

MF 09-09-10

Picklist Print

August 31, 2009 11:22:06 AM

Page 1

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC		Manufactured	No			110	Each	54.0000	1.0000			
												
Cap												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 54

44892 19

47488 35

D2600-3-BENTRevD1

Manufactured

No

110

Each

0.0000

1.0000



Extrusion Bent

D2743RevB

Manufactured

No

160

Each

294.0000

8.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 50

50281 50

Main Warehouse

ST 244

44891 2

45555 177

48275 65

B76063 41884
DP 9-8-31

1 BL 09-09-08

8 BL 09/09/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Page 2

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD		Manufactured	No			160	Each	6.0000	1.0000			
												
350 I Beam												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

4

50353

4

Main Warehouse

ST

2

47124

1

47681

1

AWM 9-9-3 ①

~~AWM 9-9-3 ①~~

D3490-3RevA

Manufactured No

160

Each

112.0000

4.0000



Cross Bolt Spacer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112

45560

22

47471

35

48276

55

** 4 BE 9-9-4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Page 3

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1RevA 		Manufactured	No			160	Each	165.0000	4.0000			
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	165
45338	2
47118	4
47657	50
48277	109

ALS4-1032-225 Purchased No



Insert

8,822.000 38.0000



4 BE 9/9/04

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	8822
107441	16
<u>110768</u>	8806

D3492-041RevC Manufactured No



Plug Assembly

3.0000 8.0000



X38 MD 09/09/10

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3
43816	3

47658

X8 MD 09/09/10

August 31, 2009 11:22:06 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Page 4

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3RevA  Wearshoe		Manufactured	No			230	Each	22.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

22

47720

11

50216

11

XI mp 09/09/10

AN8C35A

Purchased

No

230

Each

167.0000

1.0000

BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

167

102180

1

106896

1

110105

65

110847

100

XI mp 09/09/10

August 31, 2009 11:22:06 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Page 5

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA  Wearshoe		Manufactured	No			230	Each	18.0000	1.0000 			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

18

40551

1

47537

4

50231

13

X1 mo 09/09/10

D3488-041RevB

Manufactured

No



230

Each

29.0000

1.0000


Blade Fitting Assembly, LH

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

29

41853

1

44530

8

47348

20

X1 mo 09/09/10

August 31, 2009 11:22:06 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Page 6

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3RevA		Manufactured	No			230	Each	27.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27

46531

2

47440

2

47722

11

50240

12

X1

MO 09/09/10

AN6C44A

Purchased

No

230

Each

172.0000

4.0000



BOLT

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST

170

110105

4

110155

14

110665

1

110865

51

111605

50

111649

50

X4

MO 09/09/10

August 31, 2009 11:22:06 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Page 7

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8 		Purchased	No			230	Each	92.0000	1.0000			
NUT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

XI	MD 09/09/10

D3536-25RevA

Manufactured

No

230

Each

21.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	21	
45569	1	
47011	2	
47526	8	
50266	10	

XI	MD 09/09/10

August 31, 2009 11:22:06 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Page 8

Work Order ID: 51728



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA  Washer		Manufactured	No			230	Each	105.0000	8.0000			

Warehouse Loc Qty Loc Code

Location


Main Warehouse

ST 105

38139 6

45353 16

47437 83

D3791-1RevA  Wearplate		Manufactured	No			230	Each	18.0000	1.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 18

47536 8

50269 10

X8 mp 09/09/10

X1 wo 09/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Page 9

Work Order ID: 51728



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,846.000	38.0000			



Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

2746

112116

2746

X38 MO 09/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Work Order ID: 51728



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB  Bushing		Manufactured	No			230	Each	272.0000	8.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	272
34817	2
36230	8
37303	1
39587	2
40726	2
41114	2
42778	19
43754	2
44893	37
45556	69
46695	18
48278	110

X8 MD 09/09/10

AN3C5A Purchased No



Bolt

230 Each 650.0000 34.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	650
111424	8
111707	342
112314	200
112489	100

X34 MD 09/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Page 11

Work Order ID: 51728



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			230	Each	46.0000	3.0000			
Wearpad												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 46

48288 3

50321 43

AN960C816L

Purchased

No

230

Each

330.0000

1.0000



WASHER



X3 mp 09/09/10

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 330

104093 2

107520 4

110139 29

110372 36

110584 100

111424 159

D3492-043RevC

Manufactured

No

230

Each

0.0000

8.0000



Plug Assembly



48273

X8 mp 09/09/10

August 31, 2009 11:22:06 AM

Shop Packet Print

Page 11

Picklist Print

August 31, 2009 11:22:06 AM

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A  BOLT		Purchased	No			230	Each	1,060.000	4.0000			



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1060	
110372	84	
111982	976	

X4 mo 09/09/10

NAS1611-013  O-RING		Purchased	No			230	Each	320.0000	1.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	---	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	320	
106513	11	
111424	109	
111758	200	

X8 mo 09/09/10

NAS1611-010  O-RING		Purchased	No			230	Each	345.0000	1.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	---	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	345	
110715	50	
110915	295	

P40-H

W/O: 51728		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09/09/10	230	changed o-ring WAS 1611-010 for oring D2594-3 Batch#: 29908 (x8) Qty should be 8 instead of 1	MD	09/09/10	x8		7/20/10 S	
09/09/10	230	WAS 1611-013 should be qty 8 instead of 1	MD	09/09/10			7/20/10 S	

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:06 AM

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3535-25RevB

Manufactured

No

230

Each

11.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

47523

11

D3794-1RevA

Manufactured

No

230

Each

7.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

46530

1

47212

2

47721

4

MS21043-6

Purchased

No

230

Each

1,132.000

4.0000



NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1132

110584

34

111424

98

112314

1000

X1 mo 09/09/10

X1 mo 09/09/10

X4 mo 09/09/10

Picklist Print

August 31, 2009 11:22:06 AM

Work Order ID: 51728



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3493-1RevA

Manufactured

No

260

Each

115.0000

2.0000

✓



Washer



09/14/10 (1)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115

44902

15

47710

100

44902

MS21083C8

Purchased

No

260

Each

92.0000

2.0000

✓



NUT



09/15/10 (1)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

92

110584

5

111424

2

111637

21

112243

44

112492

20

112243

Picklist Print

August 31, 2009 11:22:06 AM

Work Order ID: 51728



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A BOLT		Purchased	No			260	Each	112.0000	2.0000			



09/09/10

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

112

105160

1

107596

1

107924

2

109092

2

110341

2

110342

4

111605

50

111684

50

11/16/09

AN960C816L

Purchased

No

260

Each

330.0000

2.0000



09/09/10

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

330

104093

2

107520

4

110139

29

110372

36

110584

100

111424

159

11/14/09

Picklist Print

August 31, 2009 11:22:06 AM

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3L  WASHER		Purchased	No			260 230	Each	350.0000	4.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

40

102472

40

Main Warehouse

ST

310

110450

2

110806

8

111819

300

D2741RevC

Manufactured

No

260

Each

40.0000

1.0000



Blade, 350 Skidtube



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

40

20770

0

45320

1

47113

39

(P10) →

MWD 09/09/10

09/13/09 (1)

X3
X1

47113

W/O: 51728		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-09-10	260	Seq Rack Seq ID for washer NAS1515H3L should be 230 instead of 260	MD	09-09-10			01/10/10 J

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 11:22:07 AM

Page 17

Work Order ID: 51728

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3532-1RevA

Manufactured

No

260

Each

43.0000

2.0000

Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

38161

2

44904

41

NAS1515H8L

Purchased

No

260

Each

129.0000

2.0000

WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

129

107581

34

108964

1

111650

94

August 31, 2009 11:22:07 AM

Shop Packet Print

Page 17






QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

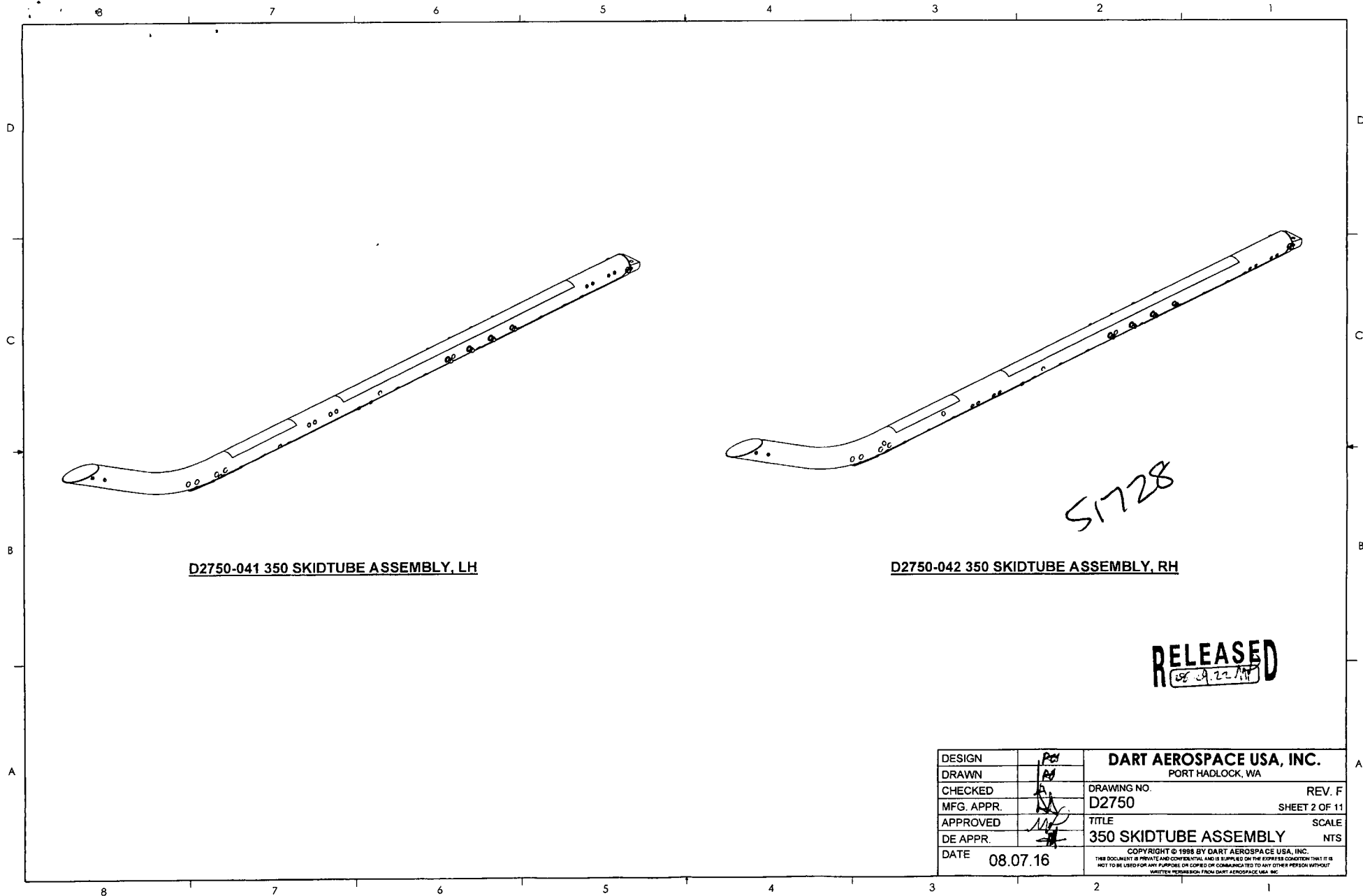
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø 0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

#571728
mf
09-08-31

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

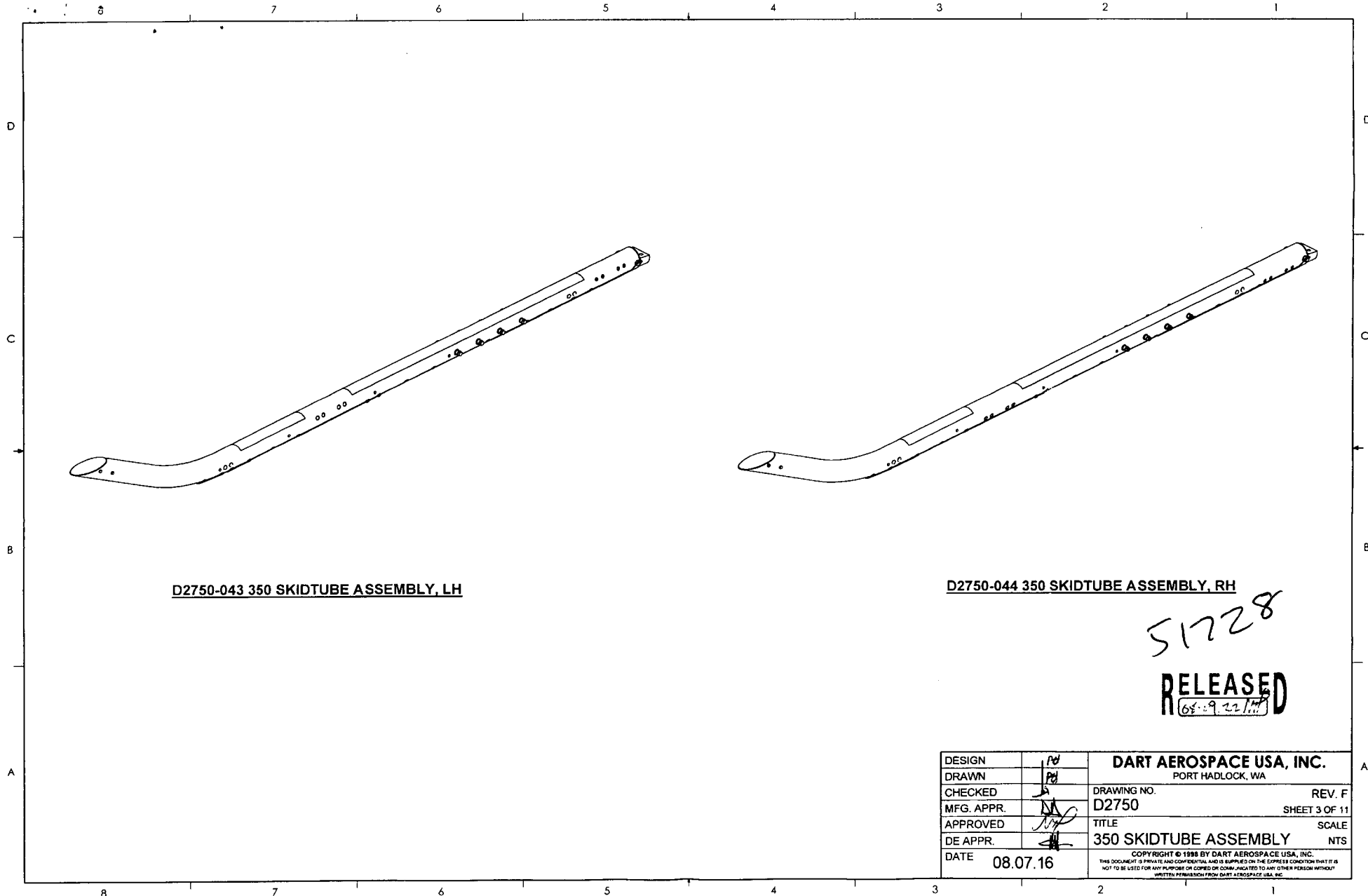


D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08.07.16

DESIGN	PCW	DART AEROSPACE USA, INC.	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	AM	DRAWING NO. D2750	REV. F
MFG. APPR.	AM	SHEET 2 OF 11	
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



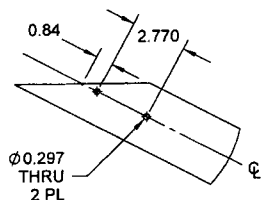
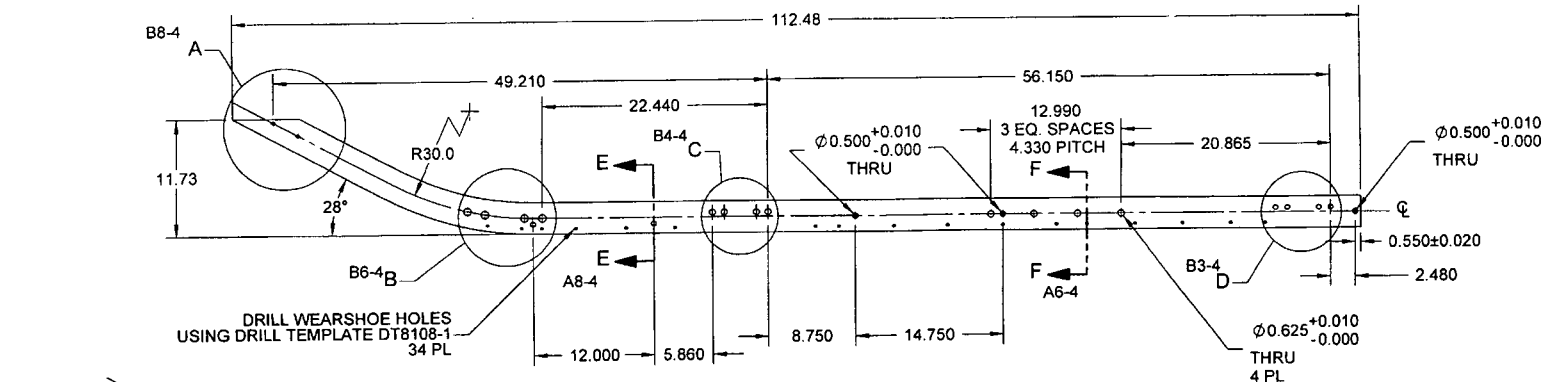
D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

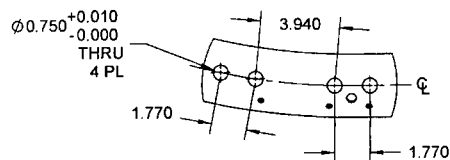
51728
RELEASED
68-9-22/111

DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	J	D2750	SHEET 3 OF 11
APPROVED	J	TITLE	SCALE
DE APPR.	J	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

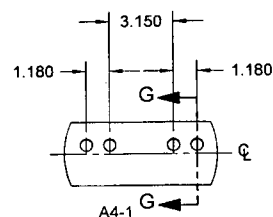
D2750-1 LH SKIDTUBE



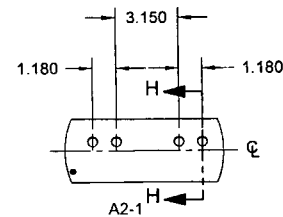
DETAIL A
SCALE 2X



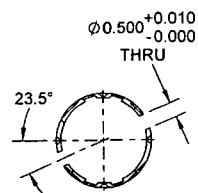
DETAIL B
SCALE 2X



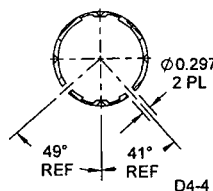
DETAIL C
SCALE 2X



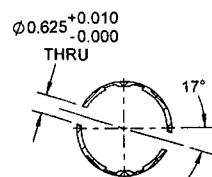
DETAIL D
SCALE 2X



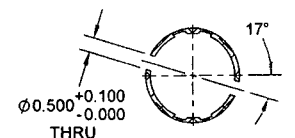
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



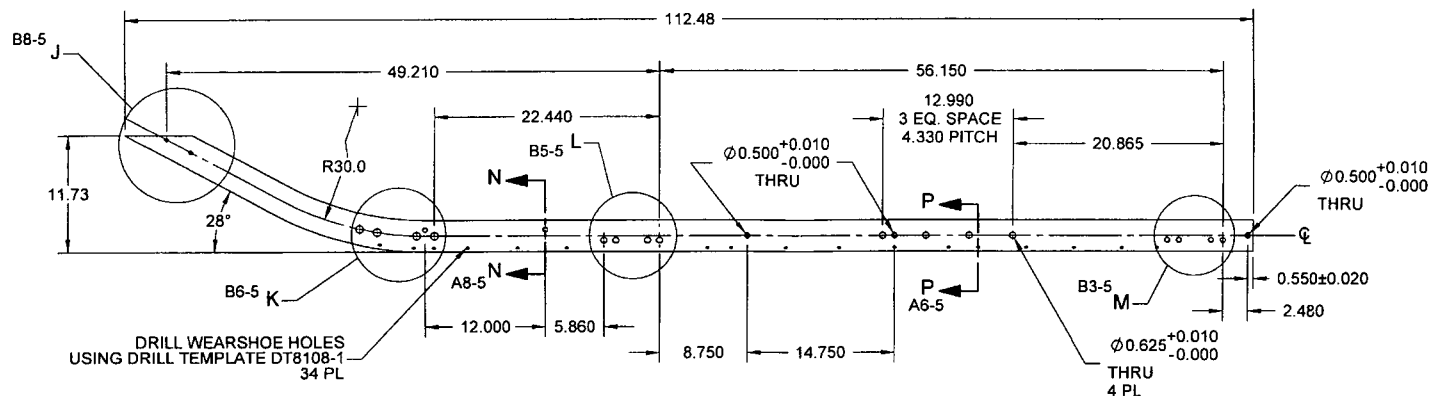
SECTION G-G
SCALE 3X, 4 PL



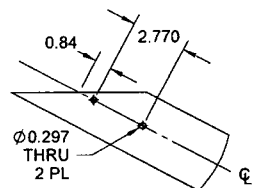
SECTION H-H
SCALE 3X, 4 PL

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

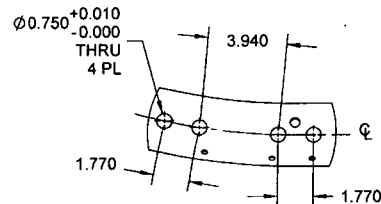
51728
RELEASED



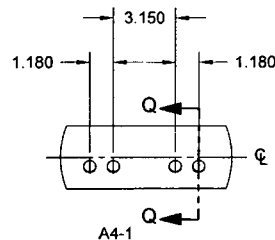
D2750-2 RH SKIDTUBE



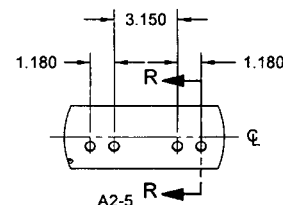
DETAIL J
SCALE 2X



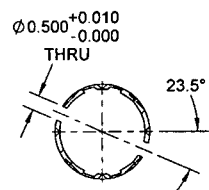
DETAIL K
SCALE 2X



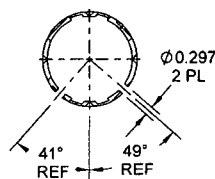
DETAIL L
SCALE 2X



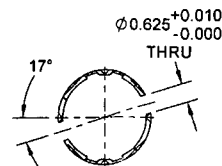
DETAIL M
SCALE 2X



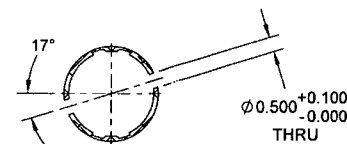
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

5728
RELEASED

8

7

6

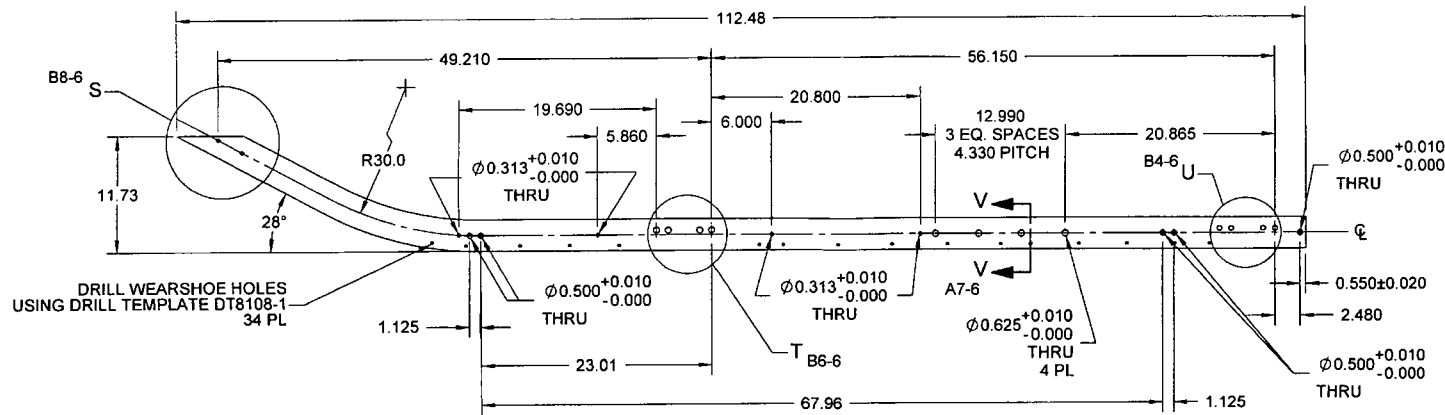
5

4

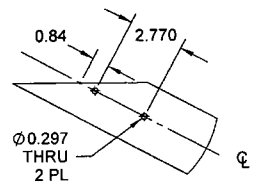
3

2

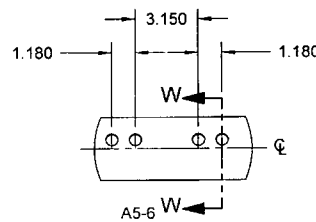
1



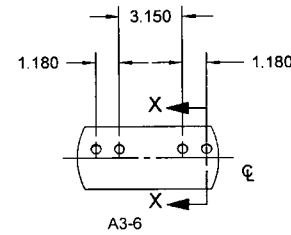
D2750-3 LH SKIDTUBE



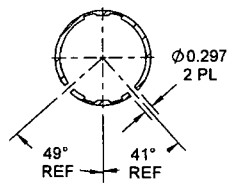
DETAIL S
D8-6
SCALE 2X



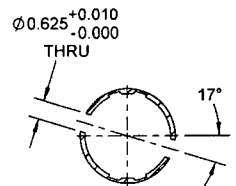
DETAIL T
C5-6
SCALE 2X



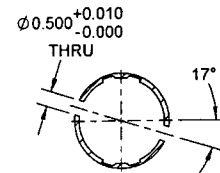
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL

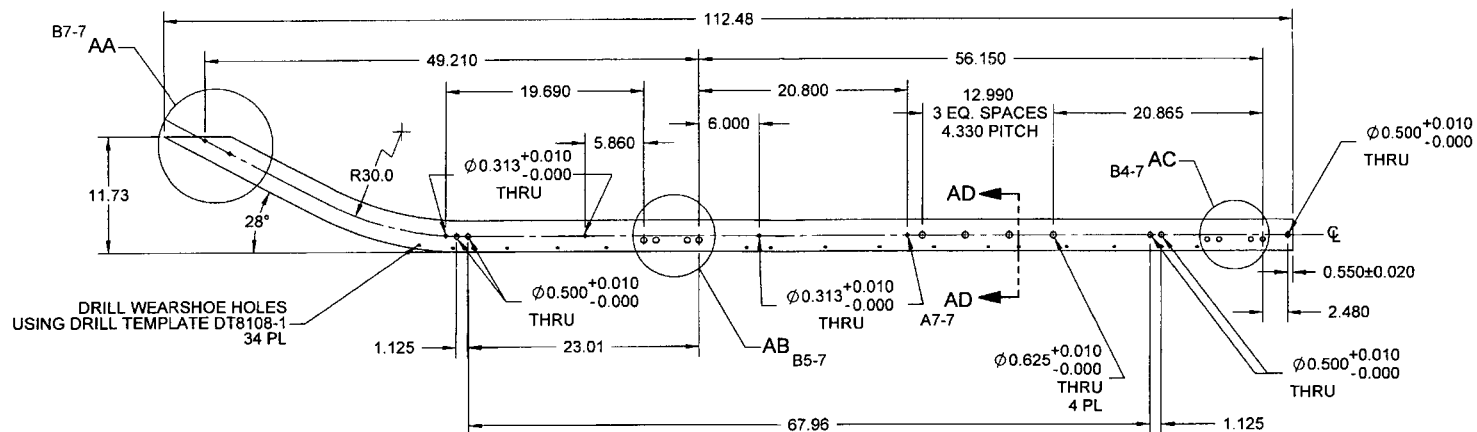


SECTION X-X
B4-6
SCALE 3X, 4 PL

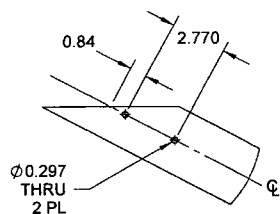
51728

RELEASED

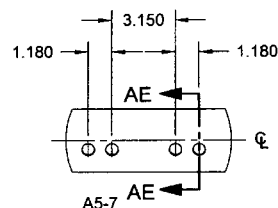
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1996 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



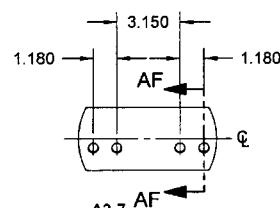
D2750-4 RH SKIDTUBE



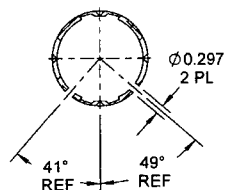
DETAIL AA
SCALE 2X



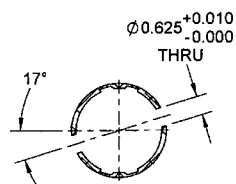
DETAIL AB
SCALE 2X



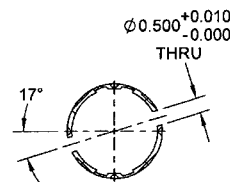
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



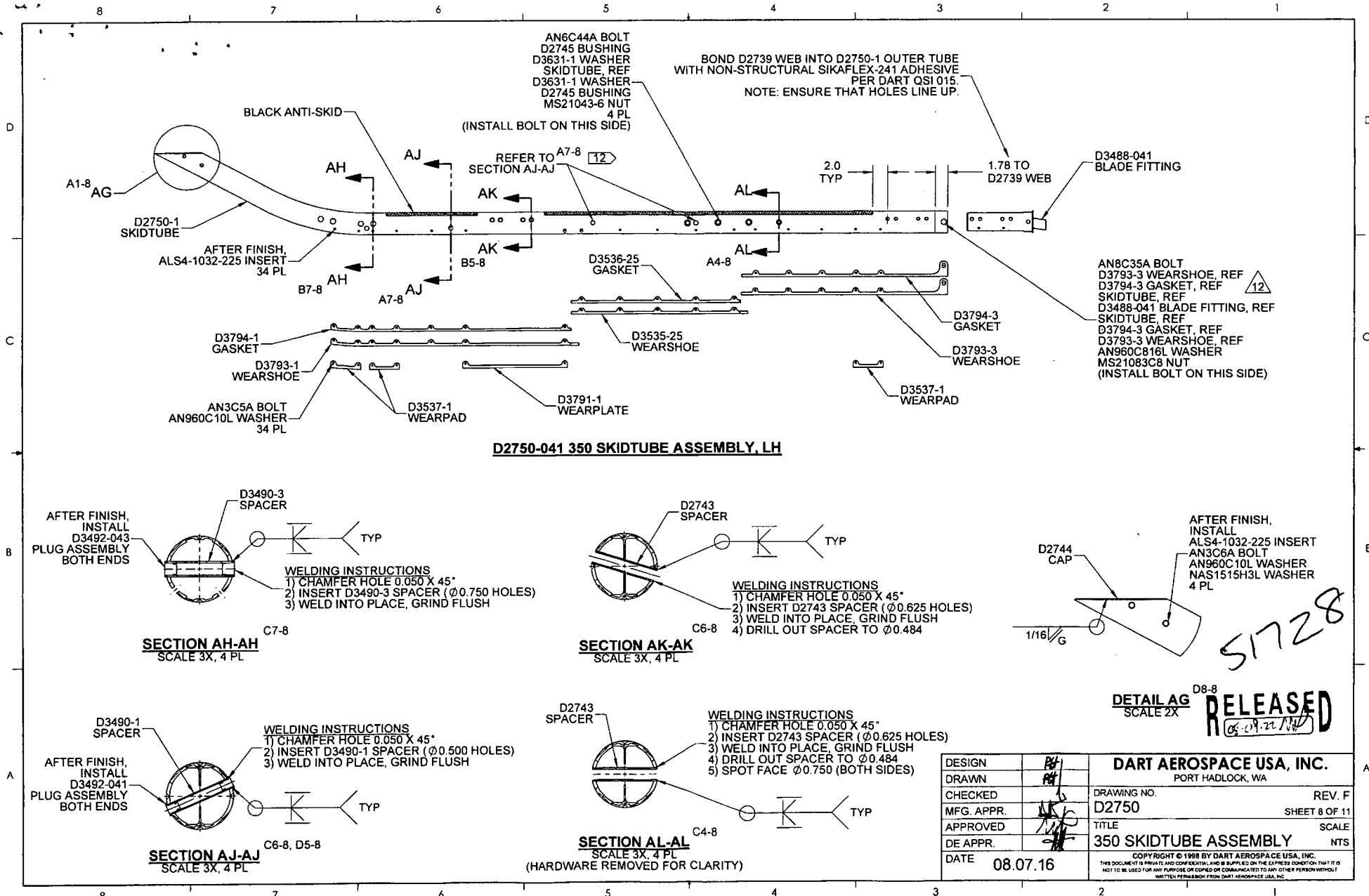
SECTION AE-AE
SCALE 3X, 4 PL



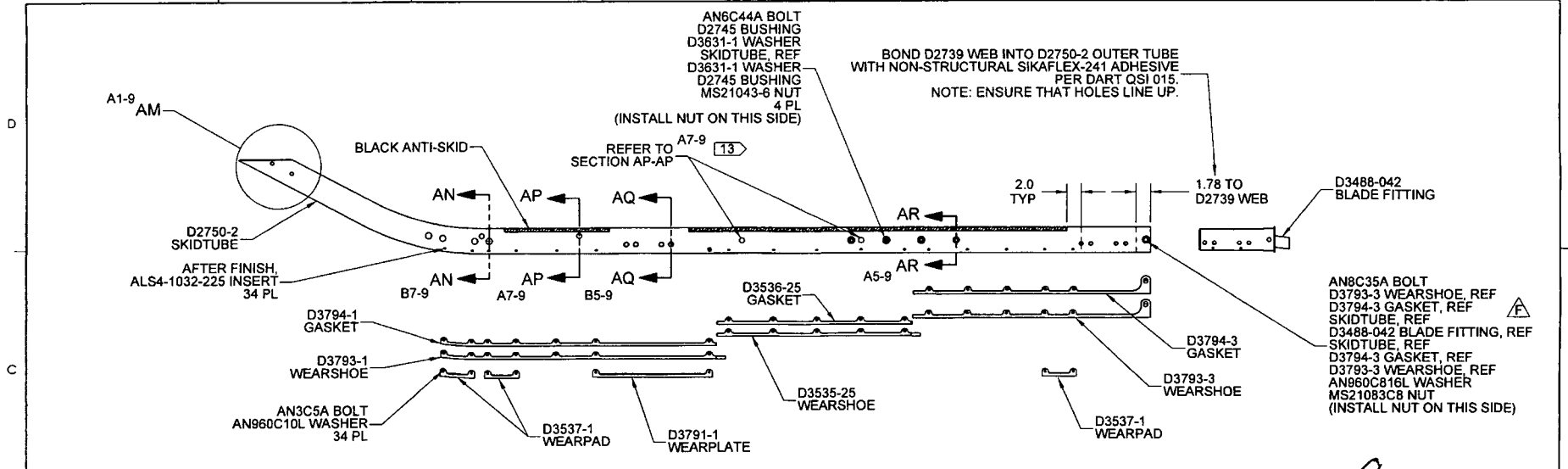
SECTION AF-AF
SCALE 3X, 4 PL

51728
RELEASED
06-09-2010

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO. D2750	REV. F
MFG. APPR.	PA	SHEET 7 OF 11	
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

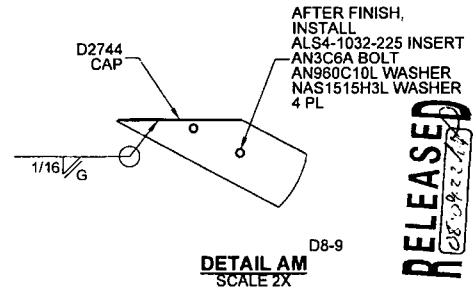
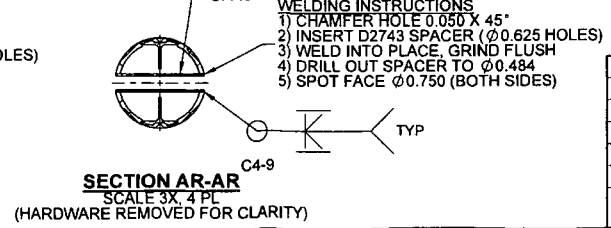
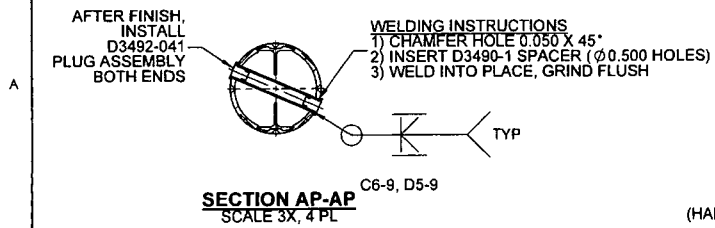
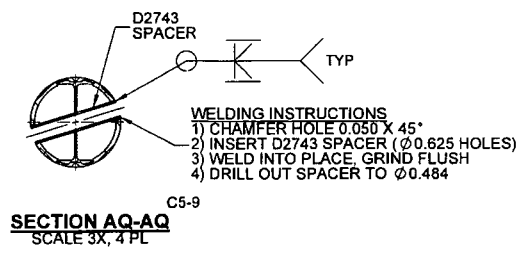
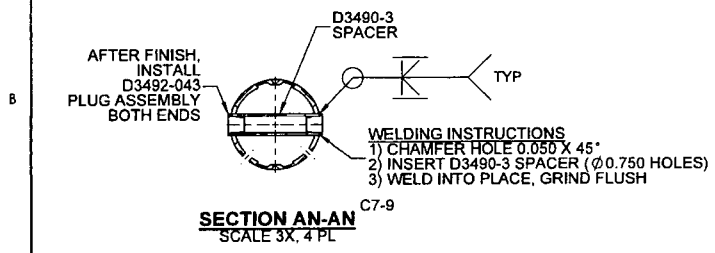


8 7 6 5 4 3 2 1



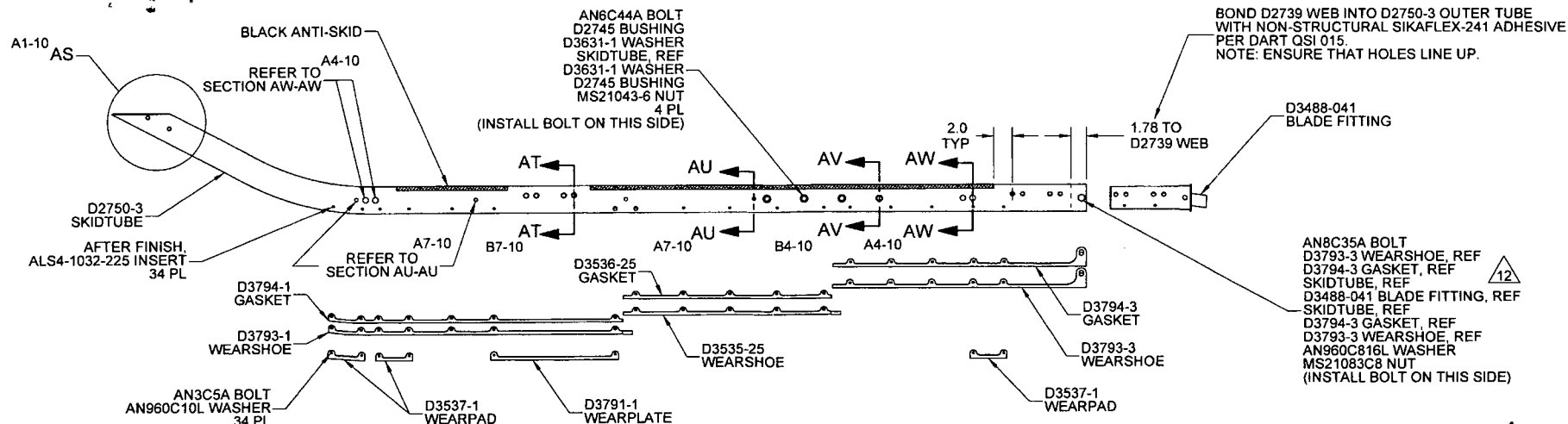
D2750-042 350 SKIDTUBE ASSEMBLY, RH

51728

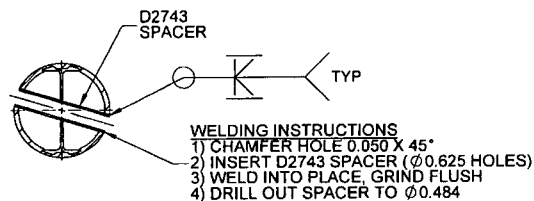


RELEASED
2025-08-22

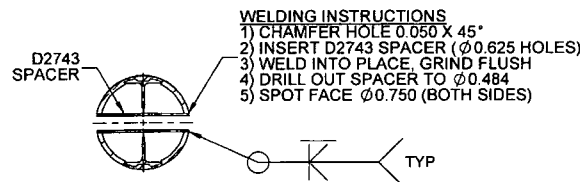
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 9 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



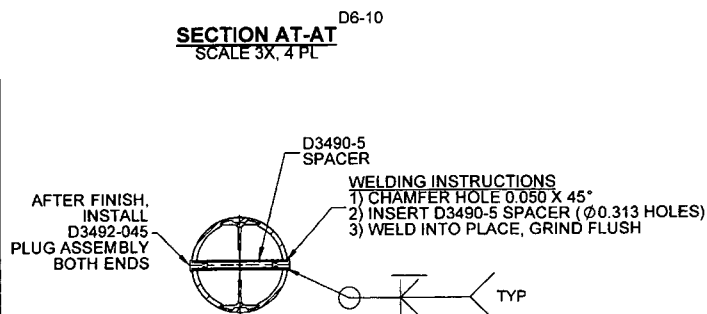
D2750-043 350 SKIDTUBE ASSEMBLY, LH



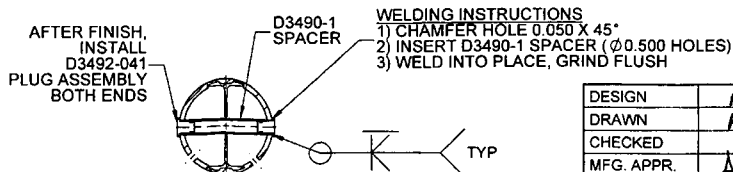
SECTION AT-AT
SCALE 3X, 4 PL



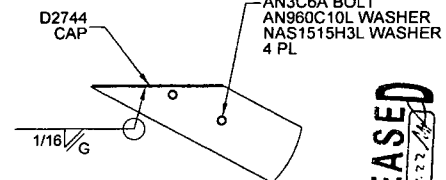
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL

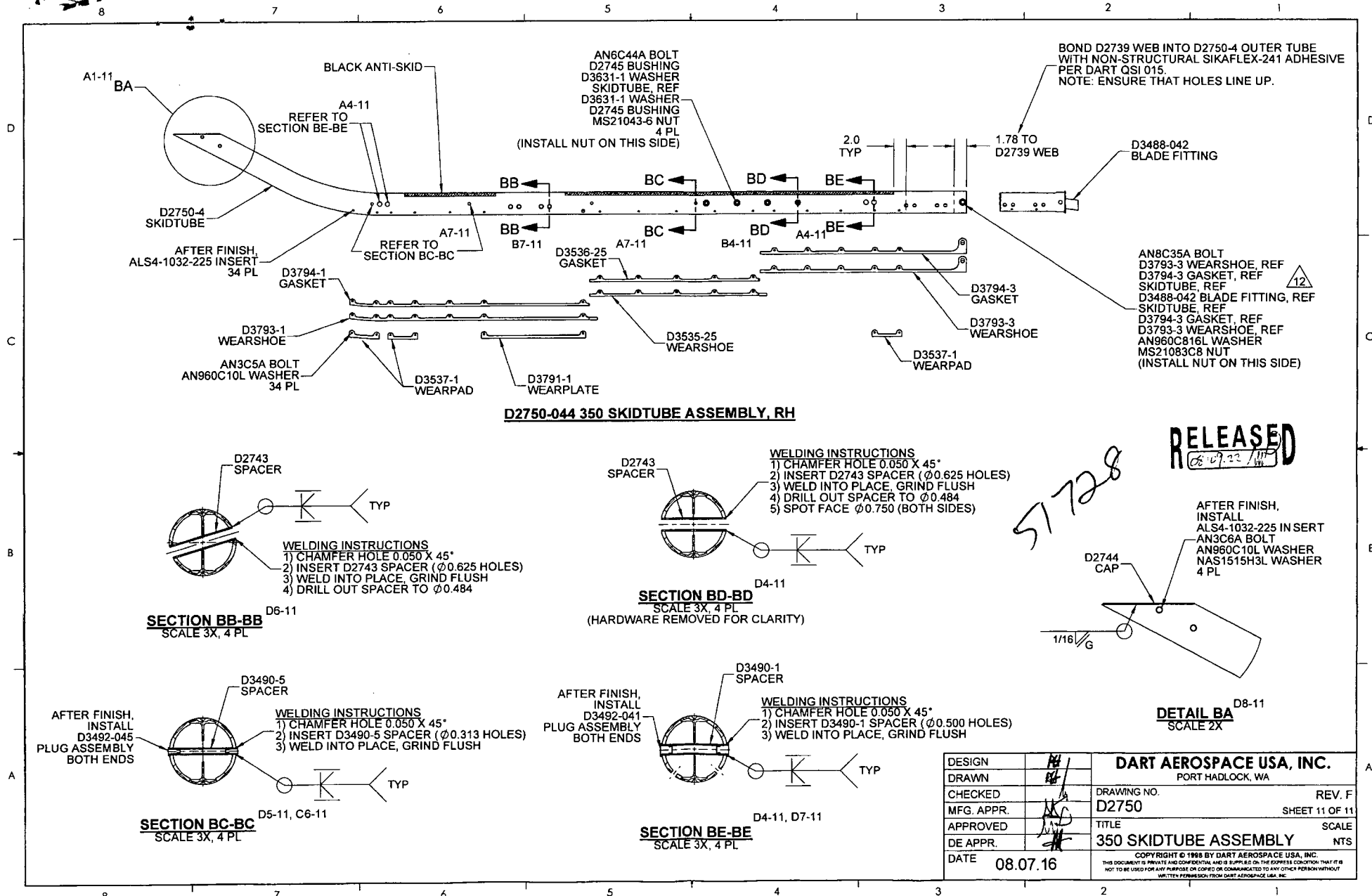


DETAIL AS
SCALE 2X

DESIGN	AS	DART AEROSPACE USA, INC.	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
DATE 08-22-16

51728



6.0 PARTS LIST (D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 004 OR LATER)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-045	WEARSHOE KIT
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11A	2	2	2	2		AN960C816L	WASHER
11B	2	2	2	2		NAS1515H8L	WASHER
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER
*20B	4	4	4	4		NAS1515H3L	WASHER

(CONTINUED ON NEXT PAGE)

5/28/88

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
*22	3	3	3	3	3	D3537-1	WEARPAD
*22A	1	1	1	1	1	D3791-1	WEARPLATE (REPLACES D3537-1)
*23A	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*23B	1	1	1	1	1	D3794-1	GASKET (REPLACES D3536-13)
*24A	1	1	1	1	1	D3535-25	WEARSHOE
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*25B	1	1	1	1	1	D3794-3	GASKET (REPLACES D3536-35)
*26A	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	AN960C10L	WASHER
*28	34	34	34	34		ALS4-1032-225	INSERT
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

51728

• COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: F

Date: 08.08.14

NO. 203

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 5011
Part number: D350 626 014
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. Del Date of Test Coupon 09.07.14

Welder Barday Elliott Date of Test Coupon 09.07.14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld